

Garant

Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 10/1,5 mm



Order data

Order number	206162 10/1,5
GTIN	4045197597816
Item class	11X

Description

Version:

GARANT Diabolo:

Special geometry, coating and carbide, specially for hard machining.

For copy milling with **angle α : 1° 30'**. Double relief ground side clearance angle.

Tolerances:

- **Corner radius: $R_1 = \pm 0.005$ mm.**
- **Angle $\alpha = \pm 20'$.**

Note:

Standard application values:

f_z for $a_p = 0.1 \times D$.

No. of teeth Z: 2

Helix angle: 30 degrees

Shank: DIN 6535 HA to h6

No. of teeth Z: 2

Flute length L_c : 6 mm

Corner radius R_1 : 1.5 mm

Overhang length L_1 incl. recess: 40 mm

maximum shank recess dia. D_6 : 11.9 mm

Recess Ø D_1 : 9.8 mm

Technical description

No. of teeth Z	2
Cutting edge Ø D_c	10 mm
Recess Ø D_1	9.8 mm
Feed f_z for copy milling in steel < 65 HRC	0.07 mm

Corner radius R_1	1.5 mm
L_2	80 mm
Feed f_z for side milling in steel < 65 HRC	0.07 mm
Overhang length L_1 incl. recess	40 mm
Shank $\varnothing D_s$	12 mm
Flute length L_c	6 mm
Overall length L	160 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
maximum shank recess dia. D_6	11.9 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	e8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.2xD for side milling
Cutting width a_e for milling operation	0.05xD for copy milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	red
Type of product	End mill

Services

Shank grinding Type HB	129100 HB
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